

Date: Friday, 5/26/2007 8:16:49 AM
User: Kim Johnston

Process Sheet

Split 1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACER	
Job Number	: 32585					
Estimate Number	: 10383					
P.O. Number	: N/A			Part Number	: D30661	
This Issue	: 5/25/2007			S.O. No.	: N/A	
Prsht Rev.	: NC			Drawing Number	: D3066 REV.B	
First Issue	: N/A			Project Number	: N/A	
Previous Run	Type	: SMALL /MED FAB		Drawing Revision	: B	
Written By				Material	: N/A	
Checked & Approved By				Due Date	: 6/10/2007	
Comment	Est.C	02-11-01	Incorporated	D3066-1 IPP	KJ/RF	Qty:
	Est Rev B	Now M6061-T6 06-06-23 JLM				50
						Unit: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
	Comment: Qty.: 0.0992 sf(s)/Unit Total : 5.9535 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: H104186 Remaining Mat = 8.5 sq ft	SAD 07/06/06
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: B Prog Rev: B 2-Deburr if necessary	SAD 07/06/06 60
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/06/06 60
4.0	QC8	SECOND CHECK
		 Signature: Jeroen J. Bo
	Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 Signature: H 09-06-22
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 32585

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

a.m

07.06.22

5

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA25

L.E. 07-06-22 5

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4/07/06/22

(5)

Job Completion



4/07/06/22

U 07-06-22

DART AEROSPACE LTD	Work Order:	325585
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAY	Audited by:	/	Prototype Approval:	N/A
Date:	07/06/06	Date:	07/06/06	Date:	N/A

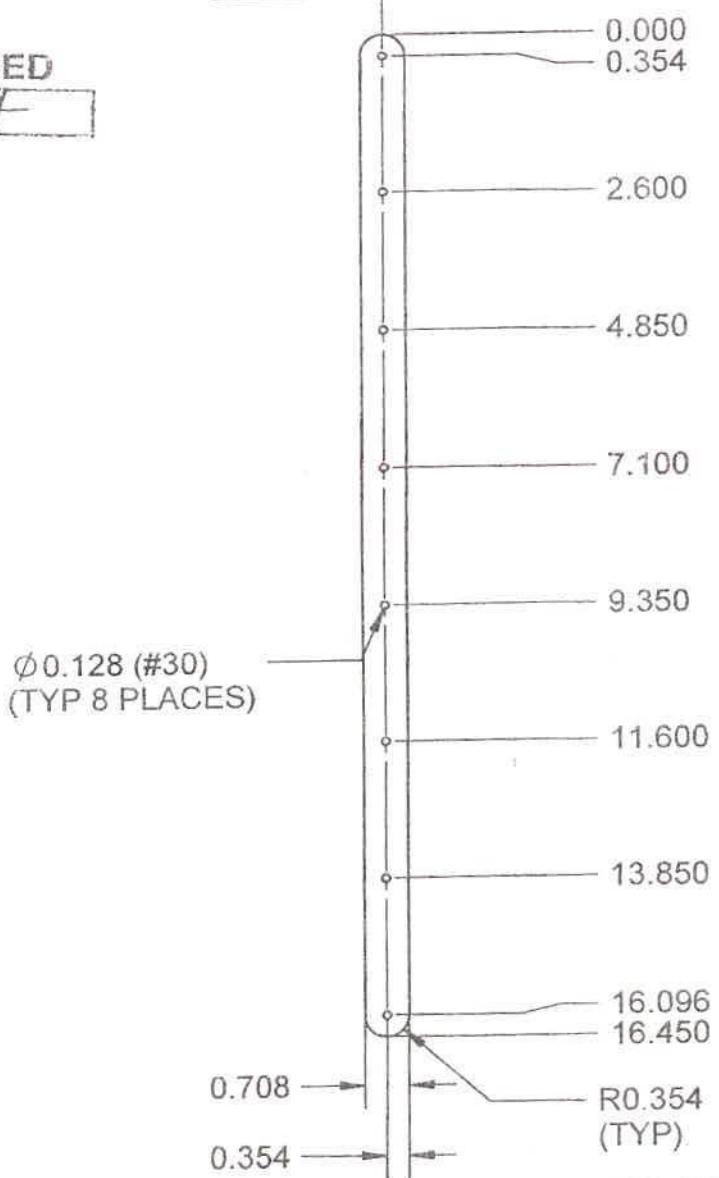
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	SJL

DART

DESIGN	1P	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	PH	APPROVED	SH	DRAWING NO. D3066	SHEET 1 OF 1
DATE	06.05.29	TITLE	SPACER	SCALE	1:3
A	02.09.11	NEW ISSUE			
B	06.05.29	ADD 6061-T6 MATERIAL			

RELEASED

06.06.20 SH

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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THE LITUAL
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SUBJ: SP-1 & 2
W/DOC. & T/F
VER. 1.0
NO. 32585